Thursday, 12/20/2007 12:14:37 PM

Dominique Dube

## **Process Sheet**

Customer

: CC-DAR01 Dart Aerospace Ltd.

Job Number

Estimaté Number

: 36351 : 10804

P.O. Number

: 12/20/2007

This Issue

Prsht Rev.

First Issue

: NC

: // : 00015 Type

S.O. No. :

: LARGE FAB ASSY

**Drawing Name** 

: PB67-43001-85

: PB674300185

**Part Number** 

**Drawing Number** 

Project Number

**Drawing Revision** 

Material **Due Date** 

: 1/5/2008

Qty:

4 Um:

Each

Written By

**Previous Run** 

**Checked & Approved By** 

Comment

**Additional Product** 

Job Number:



Seg. #:

Machine Or Operation:

Description:

1.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

**ISSUE TRAVELER** 

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

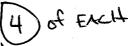
CUT AS PER DWG B67-43001-191

3.25" X 4.25" 0.063" THK 6061T6 B 165 335

B 07-12-21

CUT & DRILL HOLES AS PER DWG B67-43001-193

1.00" X 1.50" 0.125" THK 6061T6 B 105646



CUT AS PER DWG B67-43001-339

1.688" X 3.12" 0.063" THK 6061T6 B [OS]

15-67-12-21

**DE-BURR** 

3.0

M6061T6S063



6061-T6 .063 Sheet

Total:

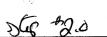


Comment: Qty.:

0.10000 sf(s)/Unit

0.40000 sf(s)

€ Soe



4.0

M6061T6S125



Comment: Qty.:

0.01090 sf(s)/Unit

Total:

0.04360 sf(s)

6061-T6 .125 Sheet

Form: rprocess

Dart Aer	ospace	Ltd						
W/O:			WORK	ORDER CHANGE	ES			
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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Date: Thursday, 12/20/2007 12:14:37 PM User: 4 Dominique Dube **Process Sheet** Drawing Name: PB67-43001-85 Customer: CC-DAR01 Dart Aerospace Ltd. Job Number: 36351 Part Number: PB674300185 Job Number: Description: Seq. #: Machine Or Operation: M6061T6S063 5.0 Comment: Qty.: Total: 0.15360 sf(s) 0.03840 sf(s)/Unit 6061-T6 .063 Sheet INSPECT PARTS AS THEY COME OFF MACHINE 6.0 QC2 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 7.0 QC8 Comment: SECOND CHECK LARGE FAB 1 LARGE FABRICATION RESOURCE 1 8.0 Comment: LARGE FABRICATION RESOURCE 1 & Debur first & CUT IN HALF AS PER DWG B67-43001-195 4 25" LONG D2914-142 B // 306 **DE-BURR** 9.0 D2914142 Comment: Qty.: (00000 Each(s) Total: 1.00000 Each(s)/Unit 3" Outer Tube LAMA 10.0 INSPECT WORK TO CURRENT STEP QC5 Comment: INSPECT WORK TO CURRENT STEP LARGE FAB 1 LARGE FABRICATION RESOURCE 1 11.0 Comment: LARGE FABRICATION RESOURCE 1 WELD AS PER DWG B67-43001-85 VISUAL WELDING INSPECTION 12.0 QC9 Comment: VISUAL WELDING INSPECTION

Dart Ae	rospace Li	td				×	٠				
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Date: Thursday, 12/20/2007 12:14:37 PM Dominique Dube User: \* **Process Sheet** Drawing Name: PB67-43001-85 Customer: CC-DAR01 Dart Aerospace Ltd. Part Number: PB674300185 Job Number: 36351 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 13.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 14.0 HAND FINISHING! Comment: HAND FINISHING RESOURCE #1 CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE) 15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION HAND FINISHING RESOURCE #1 16.0 Comment: HAND FINISHING RESOURCE #1 POWDER-GOAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8) INSPECT POWDER COAT/CHEMICAL CONVERSION 17.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 18.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 mF 08-01-07 B M106576 PICK MS21075L3 NUT PLATE QTY 4 PICK CCR264SS3-4 BLIND RIVET QTY 8 B\_ INSTALL NUT PLATE WITH RIVETS AS PER DWG B67-43001-85 19.0 MS21075L3 Comment: Qty.: 4.00000 Each(s)/Unit Total: 16.00000 Each(s) Nutolate

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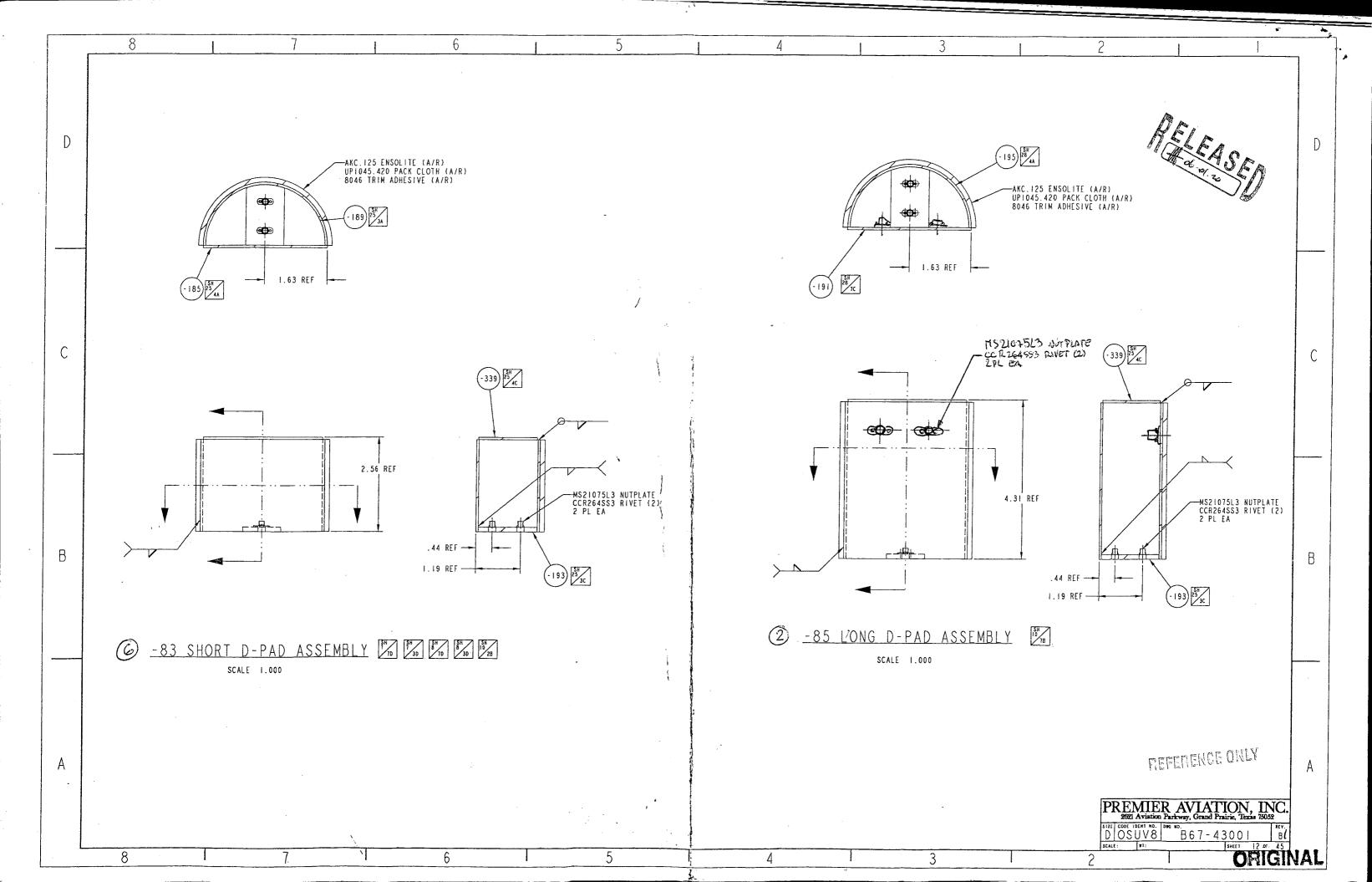
Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

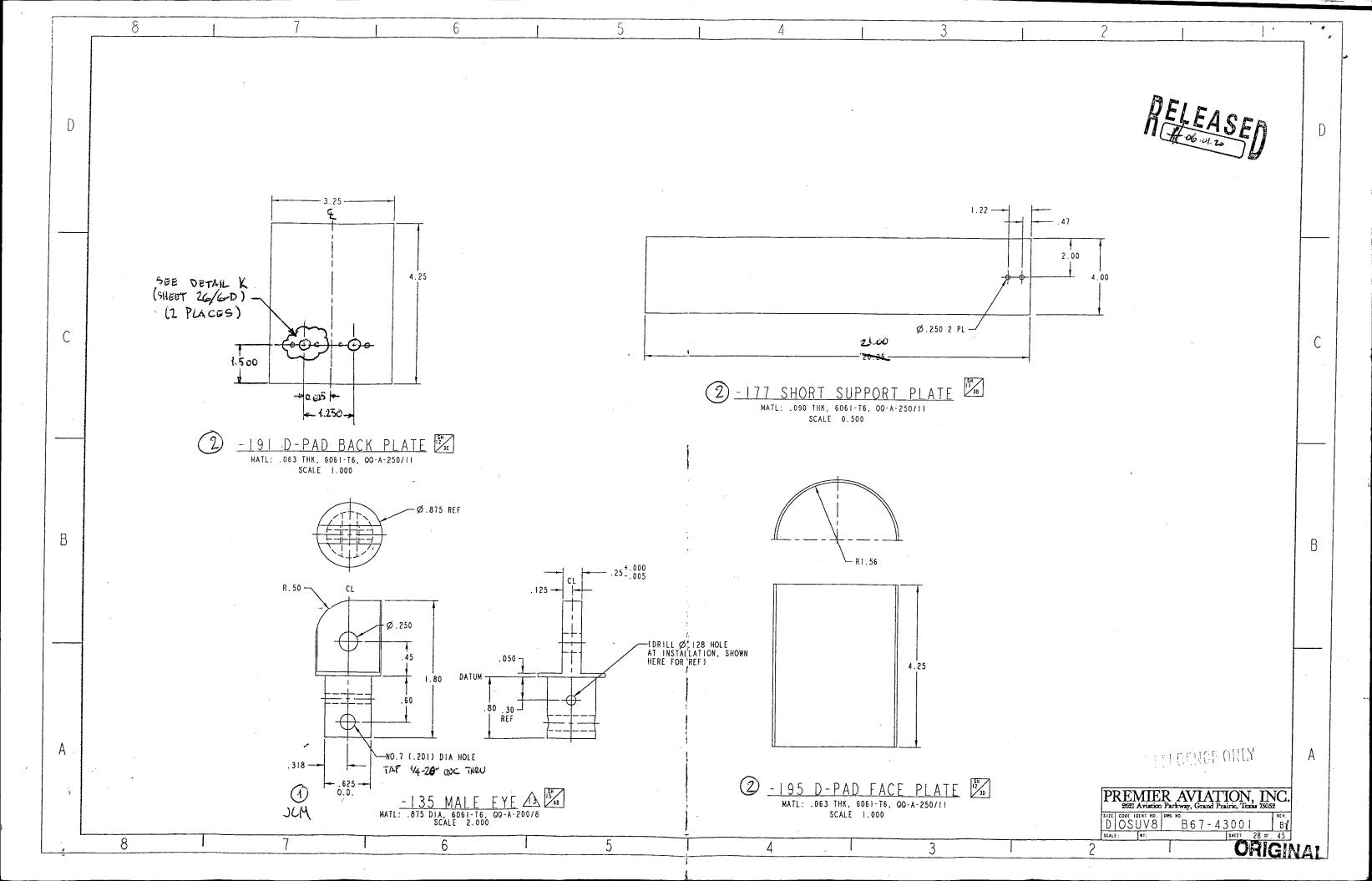
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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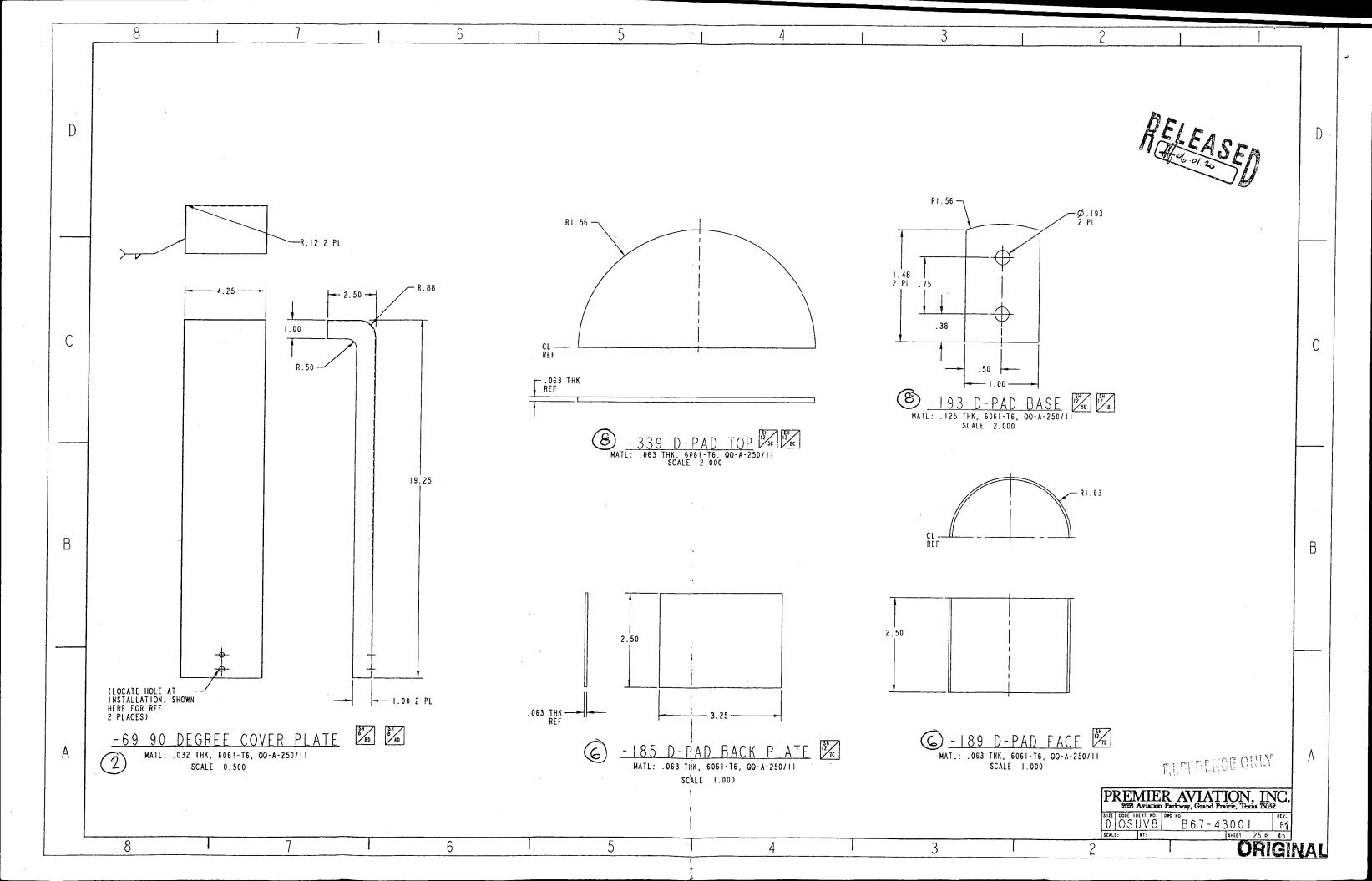
Date: Thursday, 12/20/2007 12:14:37 PM User: , **Dominique Dube Process Sheet** Customer: CC-DAR01 Dart Aerospace Ltd. Drawing Name: PB67-43001-85 Job Number: 36351 Part Number: PB674300185 Job Number: Seq. #: Description: Machine Or Operation: CCR264SS304 20.0 Comment: Qty.: 8.00000 Each(s)/Unit Total: 32.00000 Each(s) 08.01.084 RIVET PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 SEND TO TULMAR FOR FOAM & FABRIC COVERING PACKAGING RESOURCE #1 22.0 Comment: PACKAGING RESOURCE #1 RECEIVE & INSPECT FOR TRANSIT DAMAGE 23.0 QC6 DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK 24.0 **PACKAGING 1** PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 **IDENTIFY & PLACE IN STOCK** 25.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion 20.1 De 25 inspert to word & orbitors (2)
ster 2008/1/28

## **Dart Aerospace Ltd**

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A	New Issue	KJ/JLM	

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Revised by KJ/JLM

Approved

Change New Issue

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